

Work Order ID 55540

January 20, 2010 7:42:06 AM



Page 1

Item ID: D3299-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 1/20/10

Start Qty: 2.00



Cust Item ID:

Required Date: 1/29/10

Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3299

C

100



Doosan

Doosan Lathe

Hardinge CNC LATHE SMALL

0.00

Memo

0.00

Cut blank: 2.200" long

Turn as per Folio FA451 and Dwg D3299

FOLIO REV: N/A

DWG REV: C

SL 10/01/23

DEBURR

2

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

SL 10/01/23

2

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Page 2

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



HAAS 1

HAAS CNC VERTICAL MACHINING #1

0.00

10.2-7

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA451 and Dwg D3299 CHAMFER PART USING
CHAMFER MACHINE AS PER DWG D3299 Deburr

130



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

10.2-7

Memo

0.00

Quality Control

(2)

140



QC

QC8- Inspect parts - second check

0.00

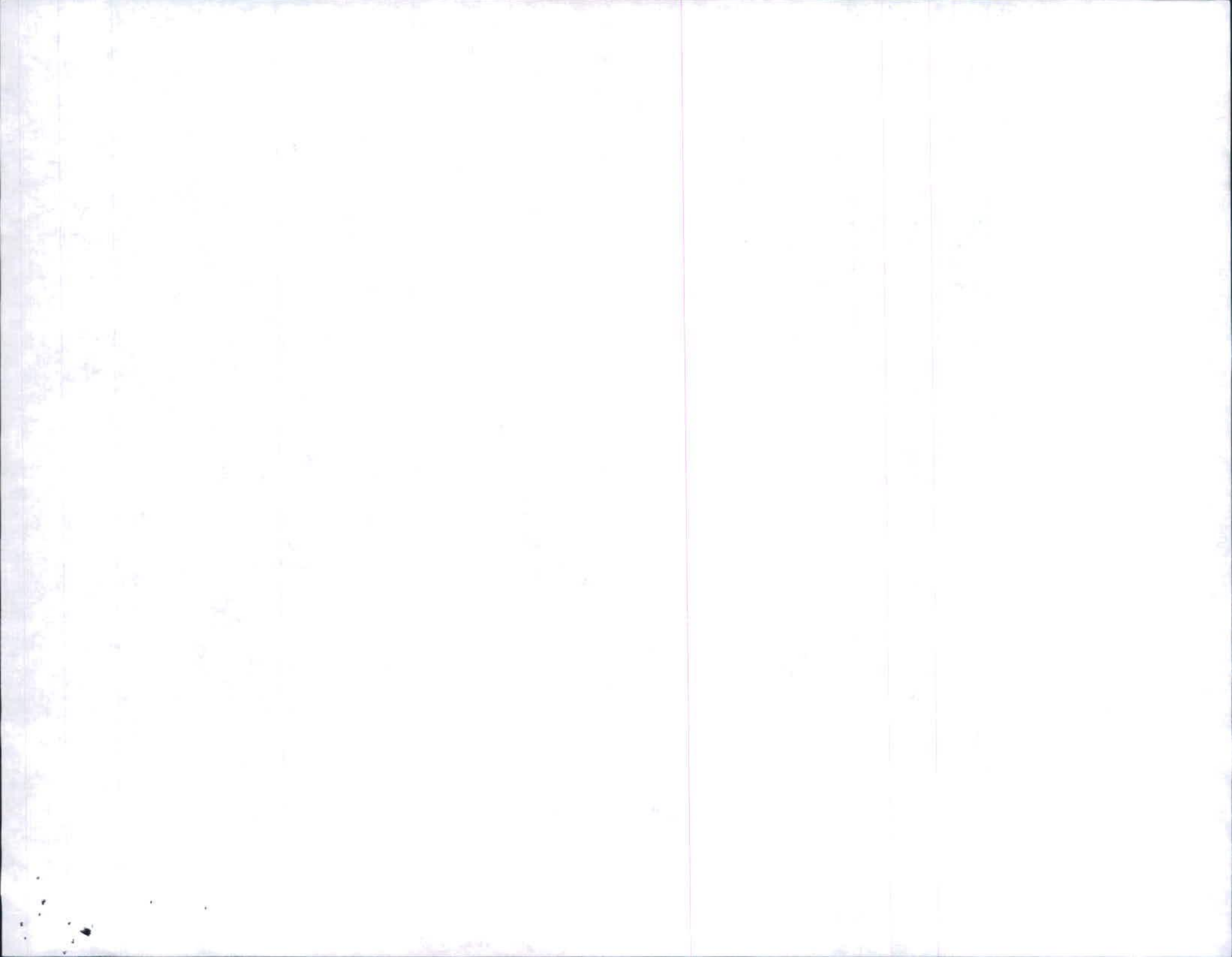
10.03.10

Memo

0.00

Quality Control

(2)



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January 20, 2010 7:42:06 AM



Page 3

Item ID: D3299-1

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Start Date: 1/20/10

Start Qty: 2.00



Cust Item ID:

Required Date: 1/29/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Outsource4

Outsource process-Anodize per QSI017 4.1.10.1

0.00

Memo

0.00

Outsource process - Anodize

Issue P/O: 11492 ☐ Anodize as per Dwg D3299 ☐ Possible
Supplier: TNM Paint ☐ Material release note is required

CY 10/3/11 2

160



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure Material Release Note is attached

10/3/18 2

170



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

8/6/19

(+2)

Work Order ID 55540

January 20, 2010 7:42:06 AM



Page 4

Item ID: D3299-1

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 1/20/10

Start Qty: 2.00



Cust Item ID:

Required Date: 1/29/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location 050

0.00

Memo

0.00

10/3/22 *(2)*

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/24 *(2)*

10-3-22 *(2)*

Picklist Print

January 20, 2010 7:42:26 AM

Page 1

Work Order ID: 55540



Parent Item: D3299-1



Parent Item Name: Fitting

Comments: IPP Rev:A 04.10.04 New issue: KJ/JLM
IPP Rev:B 07-06-11 Removed Manual Machining & Hex Bar JLM

Start Date: 1/20/10

Required Date: 1/29/10

Start Qty: 2.00

Required Qty: 2.00

IPP REV:C AS PER REV C 10-01-19 JLM VERIFIED BY:EC

M6061T6B1.250X01.25
0

Purchased

No

100

f

54.8800

0.4036



6061-T6 Bar 1.25 x 1.25



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

54.88

106259

14

109058

21.43

110001

19.45

500 JL 10/01/23

DART AEROSPACE LTD		Work Order: 55540
Description: <i>Fitting</i>		Part Number: D3299-1
Inspection Dwg: D3299	Rev: C	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø302	+0.05 -0	305	✓			
1.08	±0.030	1.085	✓			
1.65	±0.030	1.650	✓			
1.25	±0.030	1.249	✓			
.482	±0.010	.482	✓			
.041x45°	±0.030 ±.5°	.041x45°	✓			
1/4-NPT		1/4 NPT	✓			
.550	±0.010	.550	✓			
2.1	±0.030	2.099	✓			
1.00	±0.030	1.005	✓			
.550	±0.010	.550	✓			
.530	±.5°	.530	✓			
.476	+0 -0.005	.474	✓			
9/16-18unf		9/16-18unf	✓			
.20	±0.030	.198	✓			
.10	±0.030	.10	✓			
.540	±0.010	.539	✓			
.115	±0.010	.115	✓			

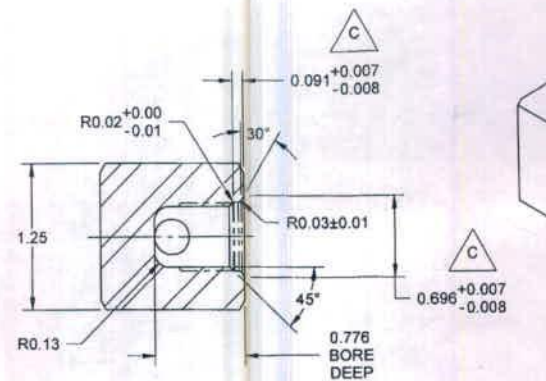
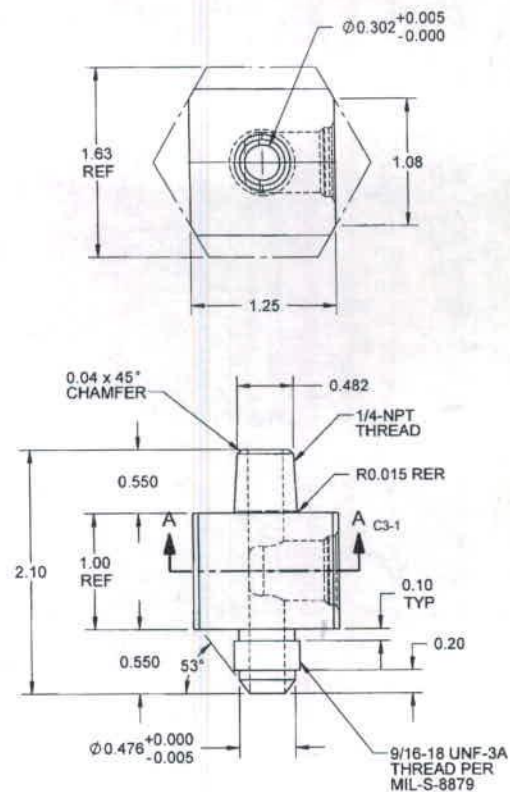
Measured by: <i>SL</i>
Date: 10/01/23

Audited by: <i>[Signature]</i>
Date: 10/03/11

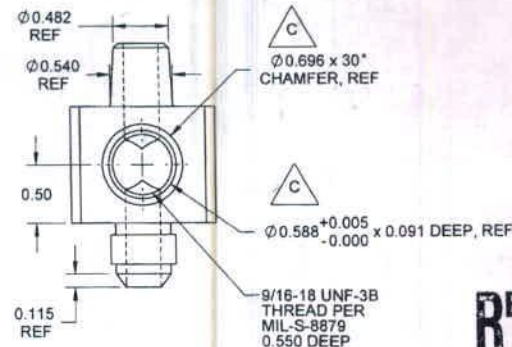
Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





SECTION A-A C5-1



RELEASED
2010-01-14

D3299-1 FITTING

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM 1.63" HEX BAR
PER QQ-A-200/8 OR QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6H1.625
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TMM PAINT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-1" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.43 lbs

C	DRAWING UPDATED TO CURRENT STANDARDS. ADD: 7 (ZIN A4-4); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZIN D2-1, C2-1, B2-1, D5-4, C4-4, B4-4, C1-4) PER CAR 09-004	RF	09.12.30
B	1.09 WAS 0.837; $\phi 302$ WAS $\phi 0.267$	RF	05.04.28
A	NEW ISSUE	RF	04.07.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	09.12.30		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3299** REV. C
SHEET 1 OF 4
TITLE **FITTING** SCALE NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO11492

Purchase Order Date 3/11/10

PO Print Date 3/11/10

Page Number 1 of 2

Order From :

VC-AND002

ANODIZING & PAINT T.N.M. INC.
21 AVIATION ROAD
POINTE CLAIRE, QC H9R 4Z2
CA

FAXED
6/10/3/10

Contact Name
Vendor Phone 514 429 7777
Vendor Fax 514 429 5108
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Please
** Rush need for the 16 of march*

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	55540	D3299-1 FITTING	3/18/10 Yes	2.00	Purolator ground	\$7.5000	\$15.00
Special Inst: BLUE ANODIZE AS PER: MIL-A-8625F TYPE 1 / 1B / 1C / 11/ 11B							
2	55530	D3299-3 FITTING	3/18/10 Yes	6.00	Purolator ground	\$7.5000	\$45.00
Special Inst: SAME AS ABOVE							
3	55531	D3299-5 FITTING	3/18/10 Yes	6.00	Purolator ground	\$7.5000	\$45.00
Special Inst: SAME AS ABOVE							
4	55539	D3299-7	3/18/10 Yes	6.00	Purolator ground	\$7.5000	\$45.00
Special Inst: SAME AS ABOVE							

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 3/11/10





21 chemin de l'Aviation, Pointe-Claire
QC H9R 4Z2
Canada
Phone:514-429-7777 Fax:514-429-5108
Email:info@tnminc.ca

Packing Slip

DATE

PACKING SLIP #

3/16/2010

- 84045



BILL TO:

SHIP TO:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

No. De Commande/PO#	CUST	TERMS	REP	SHIP	VIA	F.O.B	JOB NUMBER
11492	0094	NET 30		3/16/2010	Purolator		123504-001

PO Line#: 01

QTY DUE	QTY SHIPPED	QTY B/O	DESCRIPTION
20	20	0	P/N:VARIOUS TNM-REV:P1
2	2		P/N:D3299-1 FITTING
6	6		P/N:D3299-3 FITTING
6	6		P/N: D3299-5 FITTING
6	6		P/N: D3299-7 FITTING

Sign Here: _____

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines pièces, la responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

Packing Slip PACK01 REV: PACK01





Anodisation & Peinture TNM Inc
Anodizing & Paint TNM Inc

21 chemin de l'Aviation, Pointe-Claire QC H9R 4Z2
Telephone 514-429-7777 Fax 514-429-5108
AS9100 Rev B Certified QMS, Nadcap, Chemical & NDT

3/16/2010
FACTURE
INVOICE
Rev. 84045



CLIENT / CUSTOMER:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

PURCHASE ORDER/ 11492
NO. DE COMMANDE:

CONDITIONS/TERMS:
NET 30 JOURS/NET 30 DAYS

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
53361824	20	20	P/N:VARIOUS REV:P1 FITTING	\$7.50	\$150.00
53361825		1	Shipping Charges	\$0.00	\$0.00

SUB TOTAL: \$150.00
TPS/GST(5.00%): \$7.50
SUBTOTAL: \$157.50

TOTAL AMOUNT DUE: \$157.50

No de TPS / GST # : 891559734 RT CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE
No de TVQ / QST # : 1019307154 TQ000 CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines pièces, la responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

**Anodisation & Peinture TNM Inc**

21 chemin de l'Aviation, Pointe-Claire QC H9R 4Z2
Telephone 514-429-7777 Fax 514-429-5108
AS9100 Rev B Certified QMS, Nadcap, Chemical & NDT

C of C: 84045



3/16/2010

CLIENT / CUSTOMER:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**

**PURCHASE ORDER /
NO. DE COMMANDE:**

11492

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION PROTECTIVE FINISH CODES	PART PROCESS & TREATMENT
1	20	20	P/N:VARIOUS TNM-REV:P1 FITTING 55540 D3299-1 QTY 2 55530 D3299-3 QTY 6 55531 D3299-5 QTY 6 55539 D3299-7 QTY 6	BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER S 10/03/19

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filled and are available for viewing upon request.

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager

